



Date: Friday, 14/12/2007 9:05:10 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TUBE
Job Number :	36352		
Estimate Number :	12243		
P.O. Number :	N/A	Part Number :	D34773
This Issue :	14/12/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3477 UNDER REVIEW
First Issue :	N/A	Project Number :	N/A
Previous Run :	31403	Drawing Revision :	A
		Material :	N/A
Written By :		Due Date :	21/12/2007
Checked & Approved By :		Qty:	4
Comment :	Est Rev:A New Issue 06-02-07 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1985 sf(s)/Unit Total : 0.7938 sf(s)
 304/316 0.018 SHEET
 (M304S26GA)
 Batch: MI05591.

mf 07-12-14

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut as per Dwg D3477 (13.40" X 2.04")

mf 07-12-14

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3477

3-Tack Weld as per Dwg D3477

mf

07-12-18

4.0	VISUAL WELDING INSPECTION	VISUAL WELDING INSPECTION
-----	---------------------------	---------------------------

**Comment:** VISUAL WELDING INSPECTION

SB 07/12/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 01/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 14/12/2007 9:05:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 36352

Part Number: D34773

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/18

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 07-12-18

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007/12/18

(4)

Job Completion



2007/12/18

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

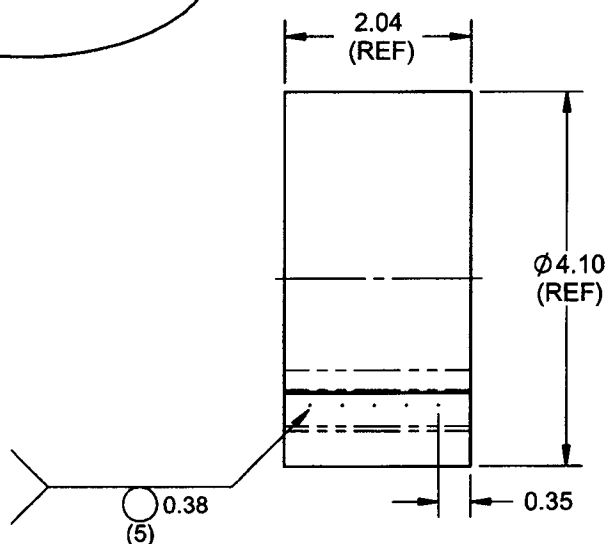
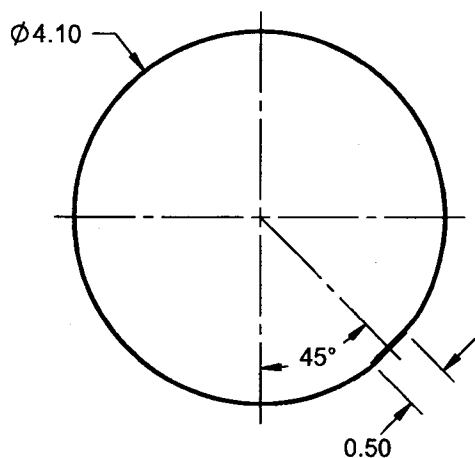
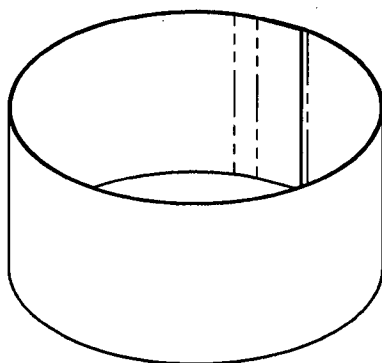
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

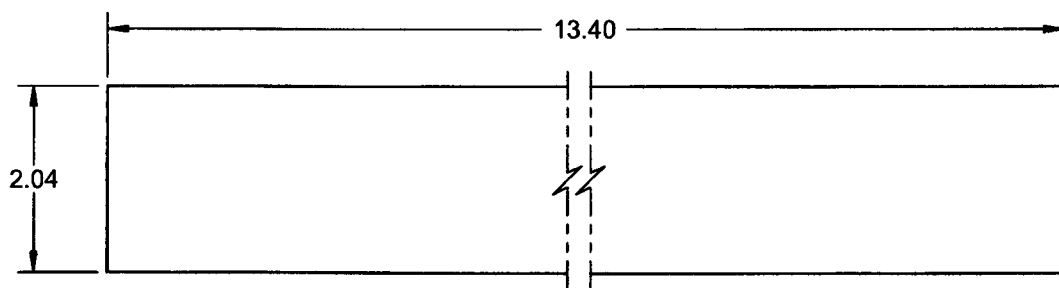


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 3 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

06.04.03
UNDER REVIEW
[Signature]
05/04/09
Dir. of Manufacturing
(Chait)



D3477-3 TUBE



D3477-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 49

EMPLOYEE: Melani Fauten

PART NUMBER: D 3477-3

JOB NUMBER: B 36352

MATERIAL TYPE: 304

MATERIAL THICKNESS: 0.018

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL	
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/12/18
QUALIFIER: SB